PN - DE19613134 A1 19971002
PD - 1997-10-02
PR - DE19961013134 19960401
OPD - 1996-04-01
TI - (A1)
Hollow plastic product manufacture and process plant
AB - (A1)
In a process for moulding a plastic product(6) with one or more hollow chambers a polymer melt is injected into a tool cavity(2) and simultaneously or subsequently a first pressurised fluid, preferably compressed gas, is injected into the melt via a nozzle(7) to form a hollow cavity and press the melt against the cavity walls. A second pressurised fluid, preferably a compressed gas, is also injected into the cavity(2) at a pressure(PGG) greater than atmospheric and acts against the melt flow to control growth of the internal gas bubble. Process equipment comprises a tool(1) with one or more cavities(2), an injection unit(4,5) with a melt injection nozzle(3), an injection nozzle(7) for injecting the first pressurised fluid and an arrangement(8) for injecting the second pressurised fluid into the cavity(2).
IN - (A1 C2)
ECKARDT HELMUT [DE]; EHRITT JUERGEN [DE]
PA - (A1 C2)
BATTENFELD GMBH [DE]
EC - B29C45/17B; B29C45/17B2
IC - (A1)
B29C45/03
- (C2)
B29C45/00
CT - (A1 C2)
DE3913109 C2 [ ]; DE2800482 A1 [ ];
US4101617 A [ ]

TI - Hollow plastic product manufacture and process plant - which injects melt into tool cavity, followed by pressurised fluid to create hollow chamber and simultaneously feeding second pressurised fluid cavity to control the melt flow
PR - DE19961013134 19960401
PN - DE19613134 C2 20000727 DW200037 B29C45/00 000pp
- DE19613134 A1 19971002 DW199745 B29C45/03 013pp
PA - (BATW) BATTENFELD GMBH
IC - B29C45/00 ;B29C45/03
IN - ECKARDT H; EHRITT J
AB - DE19613134 In a process for moulding a plastic product(6) with one or more hollow chambers a polymer melt is injected into a tool cavity(2) and simultaneously or subsequently a first pressurised fluid, preferably compressed gas, is injected into the melt via a nozzle(7) to form a hollow cavity and press the melt against the cavity walls. A second pressurised fluid, preferably a compressed gas, is also injected into the cavity(2) at a pressure(PGG) greater than atmospheric and acts against the melt flow to control growth of the internal gas bubble. Process equipment comprises a tool(1) with one or more cavities(2), an injection unit(4,5) with a melt injection nozzle(3), an injection nozzle(7) for injecting the first pressurised fluid and an arrangement(8) for injecting the second pressurised fluid into the cavity(2).

- ADVANTAGE - Better surface quality is achieved by a more controlled melt flow which prevents the gas bubble breaking through the melt.
- (Dwg.1/9)

OPD - 1996-04-01

AN - 1997-481907 [45]

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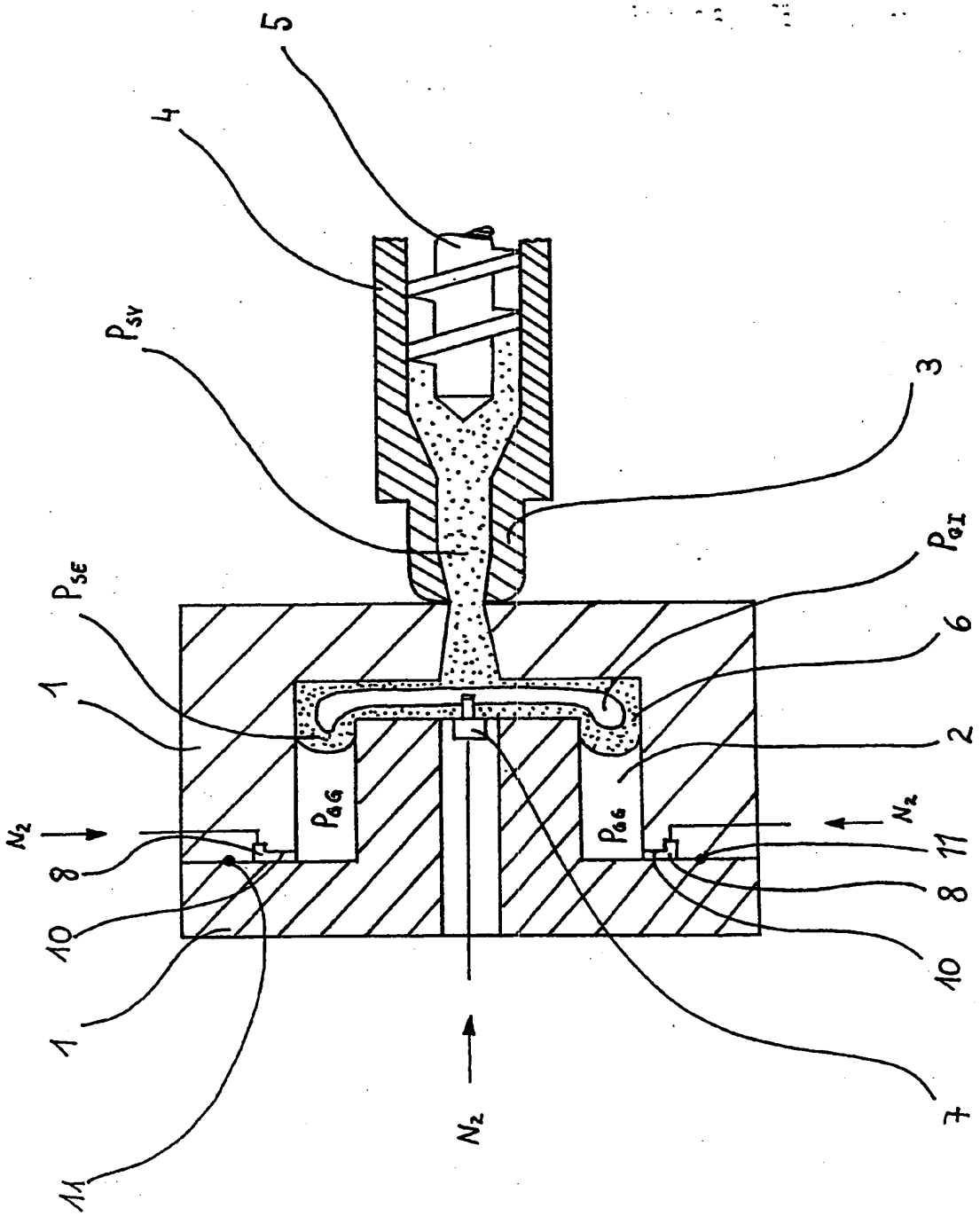

Fig. 1